

Split u6

Date: Thursday, 31/07/2008 12:18:52 PM
 User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: HELI-ACCESS STEP LH (FOLDING)		
Job Number	: 40857		Part Number	: D412630033		
Estimate Number	: 12567		Drawing Number	: IIN D412-630		
P.O. Number	:		Project Number	: N/A		
This Issue	: 31/07/2008 S.O. No. :		Drawing Revision	: L		
Prsht Rev.	: NC		Material	:		
First Issue	: / / Type : LARGE FAB ASSY		Due Date	: 25/08/2008 Qty: 2		
Previous Run	: 40268		Um:	Each		
Written By	:					
Checked & Approved By	: <u>Julie Lecocq</u>					
Comment	: Est. Rev:A New Issue 06-11-08 JLM est rev B ecn 1019, added d2807-041 EC verified by:DD					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0 DC DOCUMENT CONTROL



JLD 08.8.13



Comment: DOCUMENT CONTROL

Photocopy bluefile & create labels per PPP D412-630-033 CHG003

S 08/08/02

2.0 D2012107 Clevis



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Clevis

Pick:

Qty	Part Number	Description	Batch
1	D2012-107.	Clevis	<u>B33585 x4 40274 x1</u>

18/08/02 (X5)

3.0 D2803041 Bracket Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Bracket Assembly

Pick:

Qty	Part Number	Description	Batch
1	D2803-041	Bracket Assembly LH	<u>35826.x4 18/08/07</u>

4.0 D2804041 Bracket Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Bracket Assembly

Pick:

Qty	Part Number	Description	Batch
1	D2804-041	Bracket Assembly LH	<u>40278 18/08/07</u>

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Seq. #:	Machine Or Operation:	Description :
5.0	D2807041	Gas Spring Assembly
	Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)	
	Support Prop	
	Batch: 35751	
6.0	D2813	Washer
	Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)	
	Washer	
	Pick:	
	Qty Part Number	Description
2	D2813	Washer
7.0	D3562041	Step Assembly, LH
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)	
	Step Weldment LH	
	Pick:	
	Qty Part Number	Description
1	D3562-041	Step Weldment LH
8.0	D33951	Bushing
	Comment: Qty.: 4.0000 Each(s)/Unit Total : 20.0000 Each(s)	
	Bushing	
	Pick:	
	Qty Part Number	Description
4	D3395-1	Bushing
9.0	AN3C21A	BOLT
	Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)	
	BOLT	
	Pick:	
	Qty Part Number	Description
2	AN3C21A	Bolt

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Job Number:



Seq. #:

Machine Or Operation:

Description :

10.0 AN8C16

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Bolt

Pick:

Qty	Part Number	Description	Batch
2	AN8C16	Bolt	1C6046

11.0 AN310C8

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Nut

Pick:

Qty	Part Number	Description	Batch
2	AN310C8	Nut	M1C5436

12.0 MS24665302

Cotter Pin



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Cotter Pin

Pick:

Qty	Part Number	Description	Batch
2	MS24665-302	Cotter Pin (or AN380C3-4)	M1C6763

13.0 NAS1515H3

Washer



Comment: Qty.: 6.0000 Each(s)/Unit Total : 30.0000 Each(s)

Washer

Pick:

Qty	Part Number	Description	Batch
6	NAS1515H3	Washer	107101

14.0 NAS1515H5L

WASHER



Comment: Qty.: 4.0000 Each(s)/Unit Total : 20.0000 Each(s)

WASHER

Pick:

Qty	Part Number	Description	Batch
4	NAS1515H5L	Washer	M1C6541

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Job Number:



Seq. #: Machine Or Operation:

15.0 NAS1515H8 Washer

Description :



Comment: Qty.: 4.0000 Each(s)/Unit Total: 20.0000 Each(s)
Washer



AS 08/08/07 (X5)
106340-X11 M106575 x 9

16.0 MS210433 Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total: 20.0000 Each(s)
Nut



AS 08/08/07 (X5)
M108618-X4 M108672 x 16

17.0 MS24693C280 Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total: 10.0000 Each(s)
Screw



Pick:

Qty Part Number

Description

Batch

2 MS24693-C280 Screw (or MS24694-C565)

M101390



18.0 SMALL FAB 1



SMALL & MEDIUM FAB RESOURCE 1



AS 08/08/07 (X5)

Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per dwg D412-630 p.14

Coat all hardware with LPS3 rust inhibitor

A/R LPS3 batch: M109929

COAT exposed HARDWARE WITH LPS PROCYON.

A/R LPS PROCYON BATCH: M104251

INSPECT WORK TO CURRENT STEP

J. Lecocq 08/08/08

19.0 QC5



Comment: INSPECT WORK TO CURRENT STEP

S. Lecocq 08/08/08

72 LH

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name:

Job Number: 40857

Part Number: Job Number: 

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pick kit
all cont
in

Seq. #:	Machine Or Operation:	Description
20.0	PACKAGING 1	PACKAGING RESOURCE #1

Comment: PACKAGING RESOURCE #1

Pick Packing Kit

21.0 D28061 Bushing

SOB

Comment: Qty.: 2.0000 Each(s)/Unit Total: 10.0000 Each(s)

Bushing

Pick: Packing Kit

Qty	Part Number	Description	Batch
2	D2806-1	Bushing	35638

22.0 D28063 Bushing

SOB

Comment: Qty.: 2.0000 Each(s)/Unit Total: 10.0000 Each(s)

Bushing

Pick: Packing Kit

Qty	Part Number	Description	Batch
2	D2806-3	Bushing	35630

23.0 D28105 Strut

SOB

Comment: Qty.: 1.0000 Each(s)/Unit Total: 5.0000 Each(s)

Strut

Pick: Packing Kit

Qty	Part Number	Description	Batch
1	D2810-5	Strut	4629

24.0 D33961 Spacer

SOB

Comment: Qty.: 2.0000 Each(s)/Unit Total: 10.0000 Each(s)

Spacer

Pick: Packing Kit

Qty	Part Number	Description	Batch
2	D3396-1	Spacer	34025

25.0 AN4C6A Bolt

SOB

Comment: Qty.: 1.0000 Each(s)/Unit Total: 5.0000 Each(s)

Bolt

Pick: Packing Kit

Qty	Part Number	Description	Batch
1	AN4C6A	Bolt	M107242

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Job Number:



Seq. #: Machine Or Operation: Description :

1 AN4C6A Bolt

26.0 AN4C10A Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Bolt

Pick: Packing Kit

Qty Part Number Description Batch

1 AN4C10A Bolt

M101189 x3

AS 08/09/11 (X3)

M101189

AS 08/09/02 (X2)

27.0 AN4C15A Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Bolt

Pick: Packing Kit

Qty Part Number Description Batch

2 AN4C15A Bolt

M107082 x6

AS (X3)

M107082

AS 08/09/02 (X2)

28.0 AN44C7A Eyebolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Eyebolt

Pick: Packing Kit

Qty Part Number Description Batch

1 AN44-C7A Eyebolt

M1004116 x3

AS (X3)

M1004116

AS 08/09/02 (X2)

29.0 AN5C15A Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Bolt

Pick: Packing Kit

Qty Part Number Description Batch

2 AN5C15A Bolt

M105125 x6

AS (X3)

M105125

AS 08/09/02 (X2)

30.0 NAS1515H4 Washer



Comment: Qty.: 7.0000 Each(s)/Unit Total : 35.0000 Each(s)

Washer

Pick: Packing Kit

Qty Part Number Description Batch

7 NAS1515H4 Washer

M108558 x7

M108558 x2

All Sand Batch (not wear tested)

M108558

AS 08/09/02 (X2)

Thursday, 31/07/2008 12:18:52 PM

Julie Lecocq

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31.0	NAS1515H5	Washer
	Comment: Qty.: 7.0000 Each(s)/Unit Total : 35.0000 Each(s) Washer Pick: Packing Kit Qty Part Number Description Batch	M108334 x21 DS (x3) M108334 08/09/02 (x2)
32.0	MS210434	Nut
	Comment: Qty.: 4.0000 Each(s)/Unit Total : 20.0000 Each(s) Nut Pick: Packing Kit Qty Part Number Description Batch	M108672 x12 DS (x3) M108672 08/09/02 (x2)
33.0	MS210435	Nut
	Comment: Qty.: 3.0000 Each(s)/Unit Total : 15.0000 Each(s) Nut Pick: Packing Kit Qty Part Number Description Batch	M108583 x9 DS (x3) M108583 08/09/02 (x2)
34.0	QC4	INSPECT 100% KITS FOR COMPLÉTENESS
	Comment: INSPECT 100% KITS FOR COMPLETENESS	So 08/09/02 (x2)
35.0	PACKAGING 1	PACKAGING RESOURCE #1
	Comment: PACKAGING RESOURCE #1 Identify and pack for shipping as per PPP D412-630-033 Location: A PPP Rev: A	Kit (x3) 8/9/12 8/9/12 50 50
36.0	QC21	FINAL INSPECTION/W/O RELEASE
	Comment: FINAL INSPECTION/W/O RELEASE	08/09/15 (x3) 08/09/02 (x2) 08/09/02 (x2)
	Job Completion	U 08.09.02 2 U 08.09.12 2